

SPLT SB 08/03/17

Date: Tuesday, 3/11/2008 7:51:53 AM
User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	TUBE ASSEMBLY	
Job Number	37721-2		Part Number	D2003041	
Estimate Number	10921		Drawing Number	UNDER REVIEW	
P.O. Number	:		Project Number	N/A	
This Issue	: 3/11/2008	S.O. No. :	Drawing Revision	B	
Prsht Rev.	: NC		Material		
First Issue	: / /	Type : SMALL /MED FAB	Due Date	3/24/2008	Qty: 107 Um: Each
Previous Run	: 33030				
Written By	:				
Checked & Approved By	:	08.03.10			
Comment	: Est: 8	99.11.11 Re-format EC			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	DC	DOCUMENT CONTROL	
	Comment: DOCUMENT CONTROL		
	Photocopy bluefile & type labels per PPP D2003-041		08.03.28
2.0	M304TR0500W035	304 RD Tube 500 x .035W	
	Comment: Qty.: 0.5145 f(s)/Unit Total : 2.5725 f(s) 3.6015		
	Material: 1/2"AE x 0.035" wall AISI 304 SS tubing		Batch: M107098 FF 08-03-17
3.0	M26506	Firesleeve-crkl .375IDia	
	Comment: Qty.: 0.5250 f(s)/Unit Total : 2.6250 f(s) 3.675		
	Material: M2650-6 Heat sleeve		Batch: M103499 FF 08-03-17
4.0	MS20819J	Sleeve	
	Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s) 14.000		
	Pick:		M107534(4)
	Qty Part Number	Description	Batch
	2 MS20819-8J	Sleeve	106074 x 8X
			FF 08-03-17
5.0	AN8188J	Nut	
	Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s) 14.000		
	Pick:		14.000
	Qty Part Number	Description	Batch
	2 AN818-8J	Nut	106074
			FF 08-03-17

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

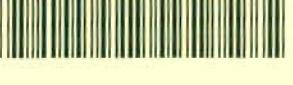
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 3/11/2008 7:51:53 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: TUBE ASSEMBLY
Job Number: 37721		Part Number: D2003041
Job Number:		
Seq. #:	Machine Or Operation:	Description :
6.0	D2182	Heat Shrink 
Comment: Qty.: 0.3750 f(s)/Unit Total : 1.8750 f(s)		2-625
Pick: Qty Part Number Description Batch		X ¹ B17067x6 B21864A FF 08-03-17
7.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1 
Comment: SMALL & MEDIUM FAB RESOURCE 1		
1-Cut: 5.88" long as per Dwg D2003 2-Cut: 6.00" long as per Dwg D2003 3-Form tube as per template D2003-041 4-Assemble as per Dwg D2003 FF 08-03-28 (7)		
8.0	QC5	INSPECT WORK TO CURRENT STEP 
Comment: INSPECT WORK TO CURRENT STEP 5 08/03/28 (EP)		
9.0	PACKAGING 1	PACKAGING RESOURCE #1 
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: STS AS 08/03/28 (X7)		
10.0	QC21	FINAL INSPECTION/W/O RELEASE  08 04 03 (d)
Comment: FINAL INSPECTION/W/O RELEASE		
Job Completion 		MF 08-03-28 W

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>4</i>	DRAWN BY <i>JP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>AE</i>	APPROVED <i>JP</i>	DRAWING NO. D2003	
DATE 99.06.08		REV. B SHEET 1 OF 2	
		TITLE 206 CABIN HEATER TUBE ASSEMBLIES NTS	
A	90.04.09	SCALE NEW ISSUE	
B	99.06.08	* UPDATE PER TEMPLATES; ADD P/N'S; 0.025 TUBING NOW 0.035 (TSR1049)	

RELEASED
 49.06.09 RE

UNDER REVIEW

CC.08.21 CB

 Some flat
lengths wrong

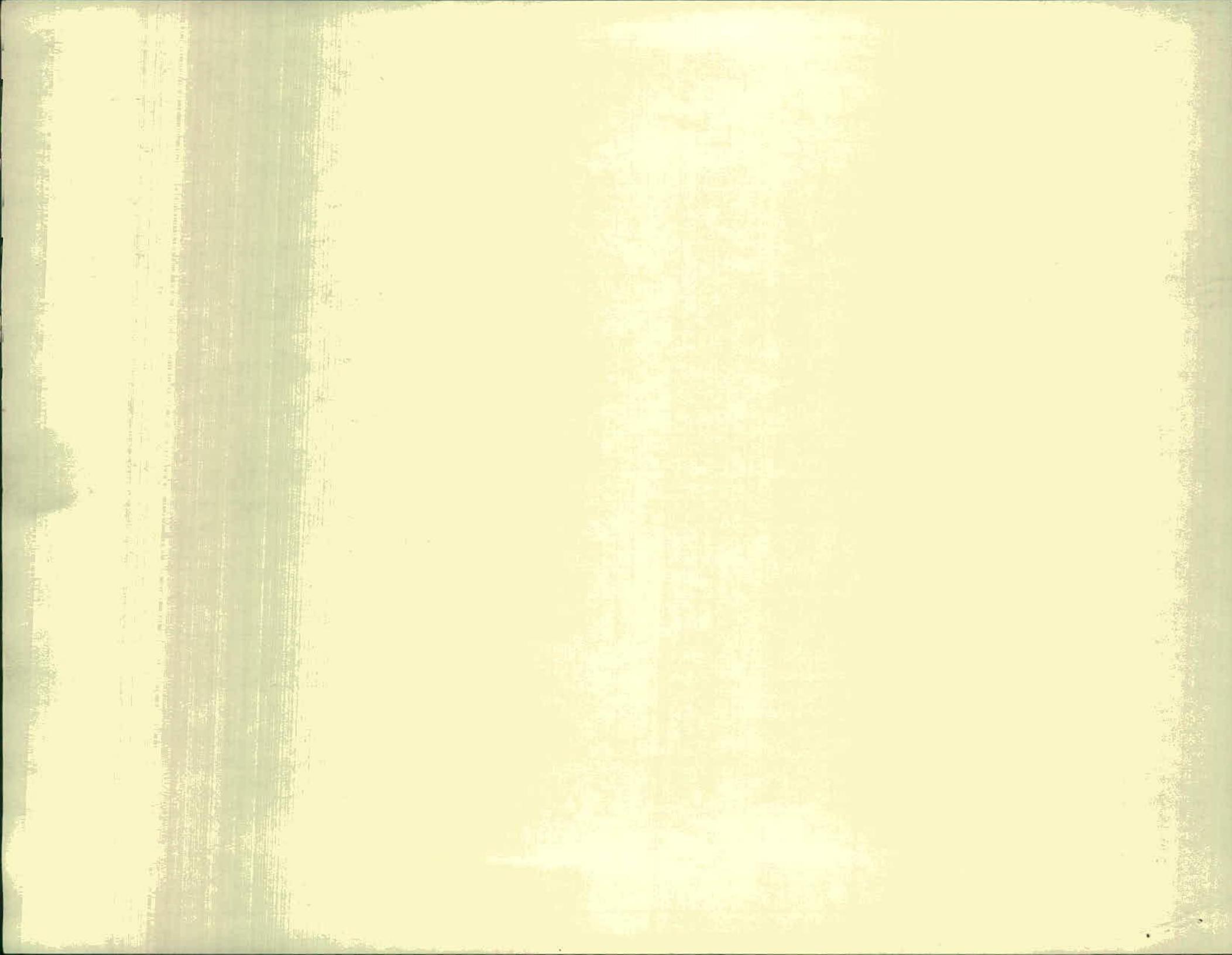
 08.03.10
SHOP COPY

RETURN TO

ENGINEERING

 UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO 37721

P/N	TEMPLATE	HEATSLEEVE LENGTH ¹	CUT LENGTH OF TUBE ²	MS20819-8J SLEEVE	AN818-8J NUT	MS20819-8D SLEEVE	AN818-8D NUT	MS20819-6D SLEEVE	AN818-6D NUT	DESC.	MATERIAL ^{4/5/7}	VENDOR OR SPEC
D2003-001	T2003-001	5.2	6.00							2 2 TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WWV-T-700/6
D2003-003	T2003-003	7.3	8.12							2 2 TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WWV-T-700/6
D2003-005	T2003-005	9.8	10.62							2 2 TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WWV-T-700/6
D2003-007	T2003-007	20.0	19.63							2 2 TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WWV-T-700/6
D2003-009	T2003-009	12.38	12.44							2 2 TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WWV-T-700/6
D2003-011	T2003-011	33.31	32.38							2 2 TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WWV-T-700/6
D2003-013	T2003-013	12.7	13.54							2 2 TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WWV-T-700/6
D2003-015	T2003-015	17.2	18.00							2 2 TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WWV-T-700/6
D2003-017	T2003-017	17.0	16.25							2 2 TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WWV-T-700/6
D2003-019	T2003-019	9.8	10.62		2 2					TUBE ASS'Y	6061-T6 0.500 OD x 0.035 W	WWV-T-700/6
D2003-021	T2003-021	N/A	2.25		2 2					TUBE ASS'Y	6061-T6 0.500 OD x 0.035 W	WWV-T-700/6
D2003-023	T2003-023	4.5	5.33		2 2					TUBE ASS'Y	6061-T6 0.500 OD x 0.035 W	WWV-T-700/6
D2003-025	T2003-025	9.8	10.60		2 2					TUBE ASS'Y	6061-T6 0.500 OD x 0.035 W	WWV-T-700/6
D2003-027	T2003-027	7.25	7.38		2 2					TUBE ASS'Y	6061-T6 0.500 OD x 0.035 W	WWV-T-700/6
D2003-029	T2003-029	17.2	18.00		2 2					TUBE ASS'Y	6061-T6 0.500 OD x 0.035 W	WWV-T-700/6
D2003-031	T2003-031	14.6	15.38	2 2						TUBE ASS'Y	CRES 0.500 OD x 0.035 W	AISI 304
D2003-033	T2003-033	29.75	29.62	2 2						TUBE ASS'Y	CRES 0.500 OD x 0.035 W	AISI 304
D2003-035	T2003-035	24.7	27.00	2 2						TUBE ASS'Y	CRES 0.500 OD x 0.035 W	AISI 304
D2003-037	T2003-037	24.81	23.38	2 2						TUBE ASS'Y	CRES 0.500 OD x 0.035 W	AISI 304
D2003-039	T2003-039	34.0	34.00	2 2						TUBE ASS'Y	CRES 0.500 OD x 0.035 W	AISI 304
D2003-041	T2003-041	6.0	5.88	2 2		208.03.17				TUBE ASS'Y	CRES 0.500 OD x 0.035 W	AISI 304
D2003-043	T2003-043	11.7	10.75	2 2						TUBE ASS'Y	CRES 0.500 OD x 0.035 W	AISI 304
D2003-045	T2003-045	3.50	2.44	2 2						TUBE ASS'Y	CRES 0.500 OD x 0.035 W	AISI 304
D2003-047	T2003-047	5.56	5.56	2 2						TUBE ASS'Y	CRES 0.500 OD x 0.035 W	AISI 304
D2003-049	T2003-049	33.2	34.00	2 2						TUBE ASS'Y	CRES 0.500 OD x 0.035 W	AISI 304
D2003-077	T2003-077	N/A	6.25				1 1			JET	6061-T6 0.375 OD x 0.035 W	WWV-T-700/6
D2003-101	T2003-101	13.25	13.13				2 2			TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WWV-T-600/6
D2003-103	T2003-103	12.38	12.00				2 2			TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WWV-T-600/6
D2003-105	T2003-105	10.75	10.60				2 2			TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WWV-T-600/6
D2003-107	T2003-107	12.75	12.25				2 2			TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WWV-T-600/6
D2003-109	T2003-109	8.25	8.125	2 2						TUBE ASS'Y	6061-T6 0.500 OD x 0.035 W	WWV-T-600/6
D2003-111	T2003-111	4.75	4.625	2 2						TUBE ASS'Y	6061-T6 0.500 OD x 0.035 W	WWV-T-600/6
D2003-116	T2003-116	4.0								HEATSLEEVE	M2650-20 CRINKLE-SOFT	STRATOFLEX
D2003-120	T2003-120	4.0								HEATSLEEVE	M2650-16 CRINKLE-SOFT	STRATOFLEX
D2003-14	T2003-14	4.0								HEATSLEEVE	M2650-14 CRINKLE-SOFT	STRATOFLEX
D2003-16	T2003-16	4.0								HEATSLEEVE	M2650-16 CRINKLE-SOFT	STRATOFLEX
D2003-205	T2003-205	9.75	9.60				2 2			TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WWV-T-700/6
D2003-207	T2003-207	3.75	3.75				2 2			TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WWV-T-700/6



DART

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2003
DATE 99.06.08	TITLE 206 CABIN HEATER TUBE ASSEMBLIES NTS	REV. B SHEET 2 OF 2 SCALE

RELEASED
99.06.08 KE
UNDER REVIEW

~~06.08.21 CB~~
 Some flat lengths
~~xx~~ wrong

Notes:

- (1) USE STRATOFLEX M2650-6 CRINKLE-SOFT HEATSLEEVE.
- (2) TUBING ASSEMBLIES TO BE CUT AND BENT IN ACCORDANCE WITH TEMPLATES.
- (3) TUBES TO BE FLARED 30° TO MATE WITH FITTINGS MADE TO MS33514.
- (4) ENSURE SEAMLESS TUBING IS USED.
- (5) INSTALL HEATSLEEVE OVER ALL TUBES WITH A DESIGNATED LENGTH OF HEATSLEEVE PER THE PARTS LIST.
- (6) 5052 (WW-T-700/4) TUBING MAY BE SUBSTITUTED WHEN 6061 TUBING IS NOT AVAILABLE.
- (7) 0.049 WALL THICKNESS CRES TUBING MAY BE SUBSTITUTED WHEN 0.035 IS NOT AVAILABLE.
- (8) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

